

Date: Tuesday, 1/24/2006 7:46:13 AM  
 User: Linda Lacelle

## Process Sheet

<b>Customer</b> :	CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> :	LEFT ARM WELDMENT	
<b>Job Number</b> :	25596			
<b>Estimate Number</b> :	12080			
<b>P.O. Number</b> :	N/A	<b>Part Number</b> :	D33543	
<b>This Issue</b> :	1/24/2006	<b>S.O. No.</b> :	N/A	
<b>Prsht Rev.</b> :	NC	<b>Drawing Number</b> :	D3354 REV. A	
<b>First Issue</b> :	N/A	<b>Project Number</b> :	N/A	
<b>Previous Run</b> :		<b>Drawing Revision</b> :	A	
	<b>Type</b> :	<b>Material</b> :	N/A	
	MACHINED PARTS	<b>Due Date</b> :	1/31/2006	<b>Qty:</b> 8 <b>Um:</b> Each
<b>Written By</b> :	SEE COMMENT BELOW			
<b>Checked &amp; Approved By</b> :	SEE COMMENT BELOW			
<b>Comment</b> :	est rev A 06.01.23 new issue EC			

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M4130NR1250	4130N ROUND BAR
<b>Comment:</b> Qty.: 0.6300 f(s)/Unit Total : 5.0400 f(s) AISI 4130 ROUND BAR 1.250" dia. batch: <u>M18490</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
<b>Comment:</b> 1-TURN AS PER FOLIO FA623 & DWG D3354 FOLIO REV: <u>A</u> DWG REV: <u>A</u> 2-DEBURR AS REQUIRED		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
<b>Comment:</b> INSPECT PARTS AS THEY COME OFF MACHINE <u>EC 06-01-24</u>		
4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
<b>Comment:</b> CONVENTIONAL MILLING MACHINE 1-Drill cotter pin hole as per dwg D3354 2-Deburr <u>EC 06-01-24</u>		
5.0	QC8	SECOND CHECK
<b>Comment:</b> SECOND CHECK <u>EC 06-01-24</u>		

Date: Tuesday, 1/24/2006 7:46:13 AM  
User: Linda Lacelle

## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LEFT ARM WELDMENT

Job Number: 25596

Part Number: D33543

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 420

*06/11/25* (8)

7.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

*SUC 06/01/25* (8) *06/01/25*

Job Completion



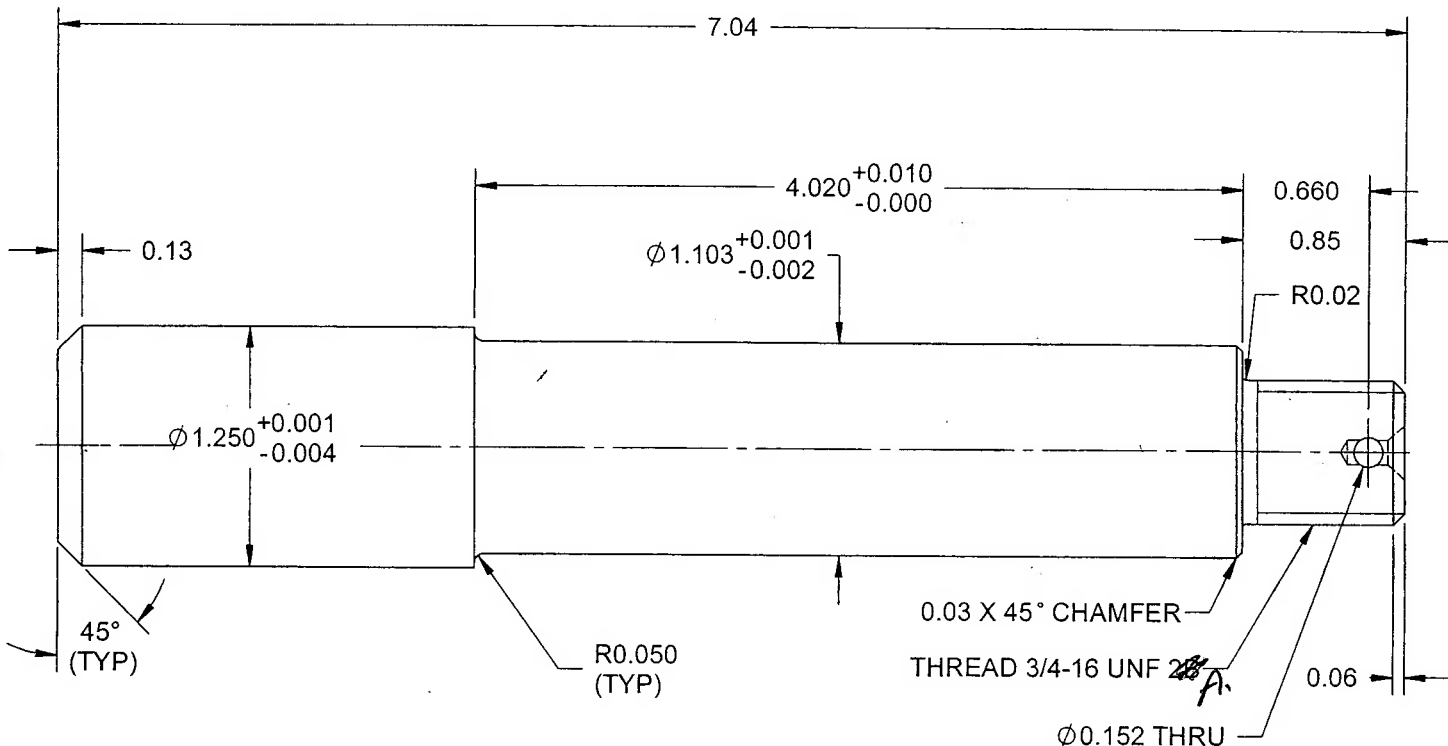
PRELIMINARY ISSUE

DESIGN <i>[Signature]</i>	DRAWN BY <i>LF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED	DRAWING NO. D3354	REV. A SHEET 4 OF 8
DATE 04.12.13		TITLE LEFT ARM WELDMENT SCALE 1:1	

PG01-573

EST LOWE

M18490  
FA624



### D3354-3 WHEEL SHAFT

#### NOTES:

- 1) MATERIAL: AISI-4130/ AISI-4140 OR ASTM A304-02/ A-434-BC/ A193-03 - GRADE-B7/ A29-03/ A322-91 OR UNS#-G41400 ROUND BAR,  $\phi 1.250$  (REF. DART SPEC. M4140H-R)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020

COPYRIGHT © 2004 BY DART AEROSPACE LTD.

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



